

CG 04 CODE KO-909-D PKG

PROCESSES

APPROVED BY

EST'D WGT NOV 5 80 LBS 37764

() KO-909-D (C)

FWP 11/3/80

STANDARD HRS.

TIME 11A M

() ()

() ()

() ()

TYPED BY: FWP 11/3/80

CG	CODE	PR	LOT	LBS
01	YC016B	93	36349	2000
01	YC016B	93	36360	1700
01	YC016B	93		

PUNCHED & CHECKED

NOV 1 1980

NOV 7 1980

TOTAL EST'D WGT 5296

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	✓ RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	2 ✓ WEIGH IN DRUM AND POUR IN	480	983-D	480
	3 DUMP IN AND STIR 5 MINS. LOT 36349	74X50	YC16B	3700
1	RECORD: START 1 PM FIN 5:36 PM			
	4 ✓ ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	✓ WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 ✓ RECORD: V-208 VOL. 40 " & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	✓ RUN 10" (514 G) WATER INTO V-211, START			
&	AGITATOR & INSTALL TEMP CHART			
SV	12 ✓ PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:45 PM TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
11	✓ WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
&	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2500	983-D	2500
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.091 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	7	226-D	7
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 12.5°F			
	& RECORD: 12.5°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34653

DUP050104781

EQUIP	PAGE 2	CG 04	KO-909-D	EST WGT 5296#	USE	N-	USE
				<i>v-247</i>	LBS	CODE	LBS

343	121	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343					
&	122	METER IN FROM V-386	M 67.915	GAL	407	27-D	373
386	123	STIR 15 MIN OR LONGER					
5	124	RECORD: DENSITY 1.019 G/ML (1.018-1.020)					

SV	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2					
	126	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)					
	127	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)					
	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE					
	129	RECORD:	START	FINISH	MINUTES		
		V-343	10:30 PM	2:38 AM	725		
		V-349	10:30 PM	2:10 AM	180		
		TIME	V-343	V-349	SV	NORMAL	
			INCHES	INCHES	PH	PH	
		AT 20 MIN	10:50 (46)	(17)	10.2	(9.3-10.0)	
		40 MIN	11:10 (41)	(15)	9.8	(9.3-10.0)	
		1 HR	12:10 (37)	(13)	9.8	(9.3-10.0)	
		2 HRS	1:10 (23)	(6)	9.8	(9.3-10.0)	
		3 HRS	5:10 (10)	(0)	9.8	(9.3-10.0)	
		FINISH	2:55 (0)		7.3	(7.5-8.5)	
		NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 & RECORD: PH					
		ASSUME 77%					
	130	SIFT IN			50	27-D	50

385	131	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F					
7	132	DUMP IN & STIR TO DISSOLVE FOR S-61			477	15-A	477

302	133	ADD 38" (465 G) WATER TO V-302					
8	134	ADD & STIR FOR 2 MIN FOR S 64	ASSUME 50%		296	7-D	148

	135	DURING STRIKE PUMP INTO PT			482	169-A	482
PT	136	PUMP IN			54	155-A	54
9	137	PUMP IN			54	160-A	54
	138	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42					

	139	DURING STRIKE RUN 15" (268 G) WATER INTO V-356					
	140	TURN ON STEAM					
356	141	ADJ TO 21" (366 G) AT 81-82°C					
10	142	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE					
	143	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN					
	144	SHUT OFF PUMP					
	145	STIR 30 MIN AT 81-82°C FOR S 55					
	146	DO NOT SHUT OFF AGITATOR					

USE
LBSN-
CODEUSE
LBS

- SV 142 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
- 11 143 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
- 144 STIR 60 MIN AT 190-194°F
- 150 HEAT TO 198-200°F IN 5-10 MIN
- 151 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
- 152 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
- 153 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
- 154 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
- 155 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
- 156 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
- 157 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
- 158 TURN OFF HOMOG & STEARATE PUMP
- 159 STIR 5 MIN AT 198-200°F
- 160 SHUT OFF STEAM
- 161 RUN IN V-385 FROM S-32 & STIR 5 MIN
- 162 RECORD: PH 3.1. (3.4-3.8)
- 163 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
& RECORD: PH _____
- 164 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 165 RECORD: PH 5.9. (6.2-6.4) & IF NECESSARY, ADJ
TO PH 6.2-6.4 & RECORD: PH 6.2 ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
- 166 DO NOT STOP AGITATOR

27-D
7-D

ST. FIN. OPR
8:02P — 11:00P 126-120
7:00AM 3:00 PM 201-409
9-P 11P 170-306
11:00 PM 5:45 AM 237

WAREHOUSE REQUEST FORM

REQUEST NO. 3598
11/04/80

DELIVER TO MAKING AREA BY 11/6/80 11 AM/PM

FOR: CG 04 CODE K0909D LOT 37764 SCHEDULED 11/04/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 3	01	YC016B	93	36349	2000		40	50	2000	-----
P2-SEC	01	YC016B	93	36360	1700		34	50	1700	-----

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

COPY-1 PROD: CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

REQUEST NO. 3598
11/04/80

DELIVER TO MAKING AREA BY 11/6/80 11 AM/PM

FOR: CG 04 CODE K0909D LOT 37764 SCHEDULED 11/04/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 3	01	YC016B	93	36349	2000		40	50	2000	
P2-SEC	01	YC016B	93	36360	1700		34	50	1700	

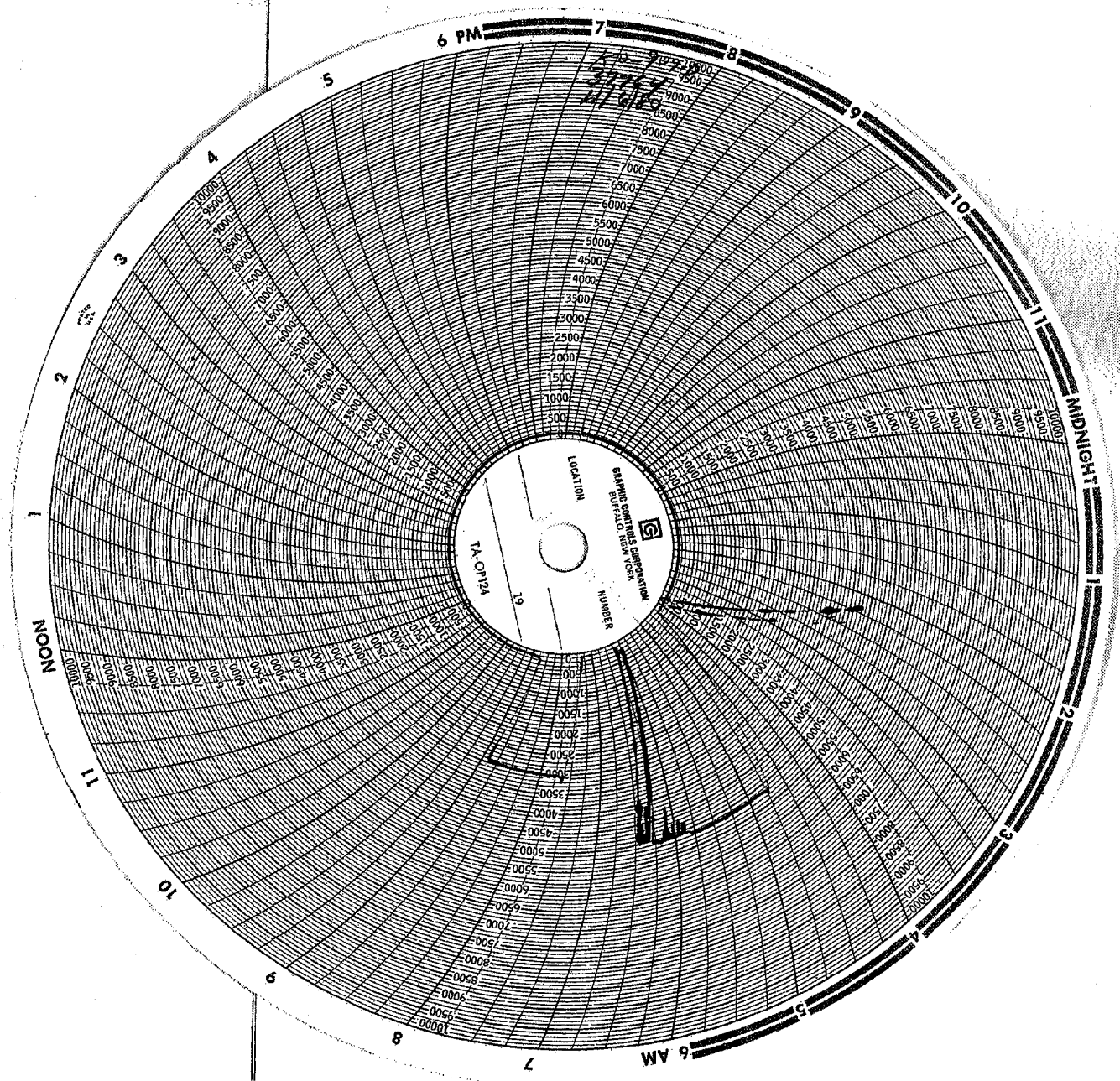
PICK UP AND RETURN TO STORAGE:

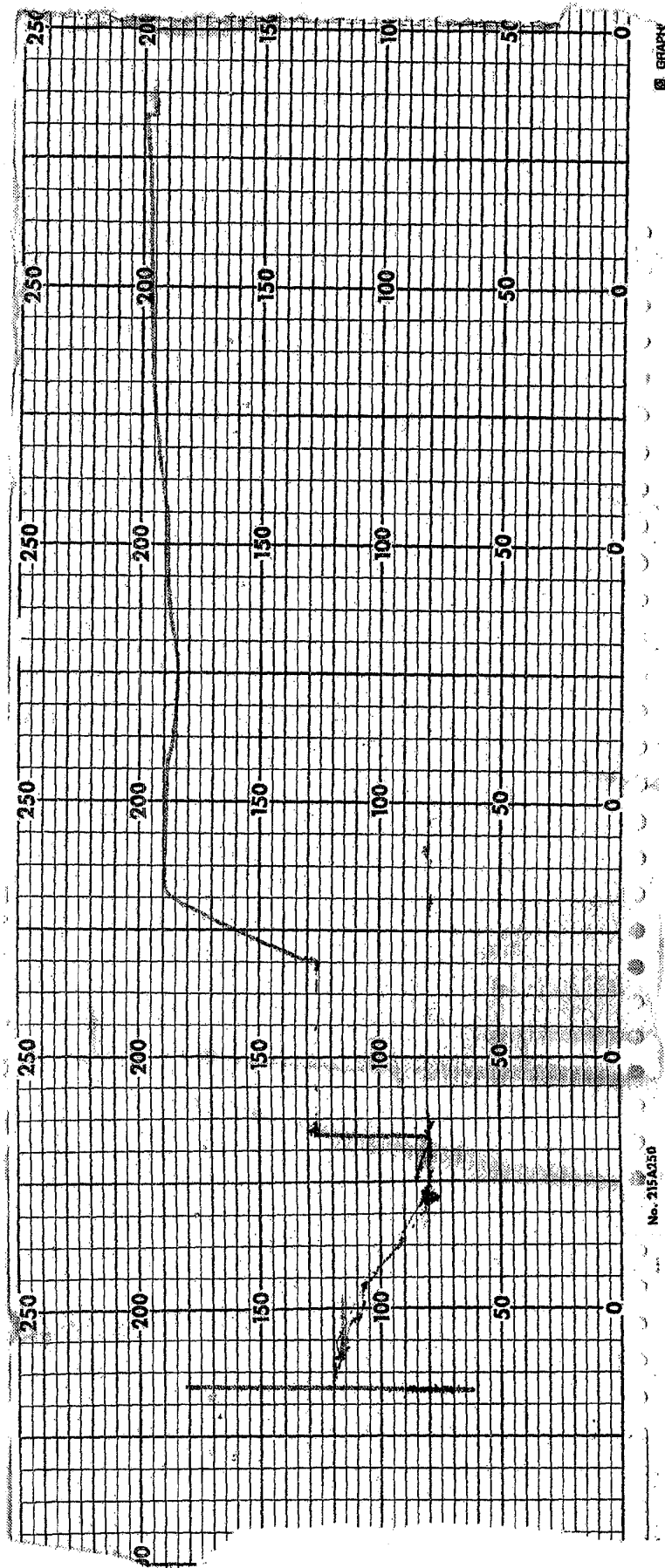
LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE 11/11/80

COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL





No. 215A250